T100289

FINISH SPECIFICATION - ARMY 3-100; NAVY SR-15

APPROVED ALTERNATE MATERIALS	CODE	FINISH
IMPORTANT: WHEN ANY OF THE FOLLOWING SUBSTITUTIONS ARE MADE, THE PART MUST BE STAMPED WITH THE SPECIFICATION OF MATERIAL USED, SUCH AS 4130, 1035, ETC.		

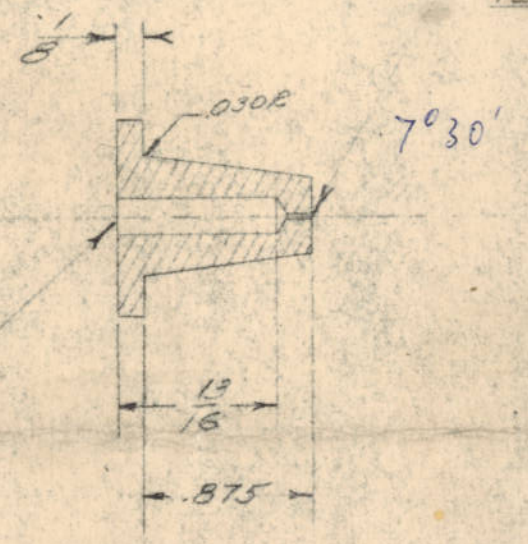
CODE	FINISH	CODE	FINISH	CODE	FINISH
MF	DICHROMATE PICKLE	MK	CHROME DIP	XJ	SHOT BLAST
NB	HOT RAW LINSEED OIL INSIDE	PC	ZINC CHROMATE PRIMER (2 COATS)	MB	CADMIUM PLATE
PA	ZINC CHROMATE PRIMER (1 COAT)	LT	ARMY YELLOW GREEN (2 COATS)	MN	ZINC PLATE

PART NUMBER	CHOICE	COM. SPEC.	ARMY SPEC.	NAVY SPEC.	TENSILE 1,000 P.S.I.	LOC.	LET.	ALTERATION	DATE	DRAFT	GROUP ENG.	CHECK	STRESS	WTS.	MAT. RELEASE
	2ND														
	3RD														
	4TH														

SHOP COPY

URF 19-1280 19.11.08 (VM)
UNDER REVIEW

#72 DRILL



KLAUS
MAKE
15
June
Due 2-15

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2. ALL DIA MUST BE CONCENTRIC WITHIN .005 T.I.R. OF #72 HOLE
1. THIS TOOL USED IN CONJUNCTION WITH TOOLS T100286, T100287, & T100288

NOTES:-

KIND	STOCK	COM. SPEC.	ARMY SPEC.	NAVY SPEC.	DIA.	THICK	WIDTH	L'GTH	TENSILE 1,000 P.S.I	FINISH	LOC.	UNIT FIN. WEIGHT	TOTAL FIN. WEIGHT
AL. AL.	BAR	24ST	QQ-A-354	COND. T	1	-	-	1¼	62	NONE			
MATERIAL					STOCK SIZE								

DO NOT SCALE DRAWING — WORK TO DIMENSIONS ONLY

DIMENSION LIMITS UNLESS OTHERWISE SPECIFIED
FRACTIONAL ±1/32 DECIMAL ±.010 ANGULAR ±1/2°

BREAK ALL SHARP MACHINED CORNERS APPROX. .015 RAD. OR CHAMFER

ALL BEND RADII TO BE — UNLESS OTHERWISE SPECIFIED

SEE BELL PROCESS SPEC. 4030 FOR EXPLANATION OF FINISHES

(3) FINISH ALL SURFACES NOT OTHERWISE SPECIFIED

(3) SMOOTH MACHINE (3A) MEDIUM MACHINE (4) ROUGH MACHINE D.G.— DISC GRIND

SCALE FULL
CAL. WT. LBS.
ACT. WT. LBS.
ARMY NONE
NAVY
HEAT TREAT SPEC.
DRAWING SIZE B

Bussey 2-11-49

DRAFTSMAN	GROUP ENG.	CHECK	STRESS	WEIGHTS	PROJ. ENG.	ENGINEER	ENG. PLAN	CUSTOMER
CARPENTER	—	[illegible]	—	—	[illegible]			
2-10-49	—	2-11-49	—	—	2-11-49			

BELL AIRCRAFT CORP.
BUFFALO, N.Y.

TITLE: CENTERING PLUG TAIL ROTOR DRIVE SHAFT

BASIC NUMBER: T100289

SHOWN / OPP.

REQUIREMENTS PER UNIT DWG. NO.: T100289 — PART NUMBER: CENTERING PLUG — NAME OF PART

FINAL ASSEMBLY CODE NO.

LAYOUT NO. — SUPERSEDES — SUPERSEDED BY

PART NO.	MODEL	NEXT ASSEMBLY	REQ.

REQUIREMENTS PER AIRPLANE (CONT.)

PART NO.	MODEL	NEXT ASSEMELY	REQ.
	H3D		

REQUIREMENTS PER AIRPLANE

ECO NO.	SHT. OF SHTS.

ABOVE ECO'S NECESSARY TO COMPLETE PRINT

E-4-16